

Work Order ID 68534

Thursday, April 14, 2011 3:58:48 PM



Page 1

Item ID: D3574-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 4/14/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

B11-4-18

2

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-18

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/16/18

72

W/O:		WORK ORDER CHANGES						
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Customer:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Deburr if necessary.

4/14/08/18 (2)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5/10/18

(2)

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

4/14/18 (2) SP

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Page 3

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/19 [Signature]

MF

11-04-19

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Picklist Print

Thursday, April 14, 2011 3:58:55 PM

Page 1

Work Order ID: 68534



Parent Item: D3574-2



Parent Item Name: Cabin Floor Protector

Start Date: 4/14/2011

Required Date: 4/20/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,652.715		67.23362			
GE PLASTICS LEXAN SHEET													

B11-4-18

Location

Loc Qty

Loc Code

MAT018

2652.715789

115261

632

116236

2020.71579

115261

②

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DART AEROSPACE LTD		Work Order:	48534
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	✓		V B 02	
7.37	+/-0.030	7.37	✓		T B 01	
10.75	+/-0.030	10.75	✓		T	
11.00	+/-0.030	11.00	✓		T	
15.25	+/-0.030	15.25	✓		T	
25.87	+/-0.030	25.87	✓		T	
39.75	+/-0.030	39.75	✓		T	
44.75	+/-0.030	44.75	✓		T	
53.51	+/-0.030	53.51	✓		T	
63.50	+/-0.030	63.50	✓		T	
65.25	+/-0.030	65.25	✓		T	
10.75	+/-0.030	10.75	✓		T	
11.00	+/-0.030	11.00	✓		T	
14.75	+/-0.030	14.75	✓		T	
25.50	+/-0.030	25.50	✓		T	
25.75	+/-0.030	25.75	✓		T	
26.00	+/-0.030	26.00	✓		T	
32.87	+/-0.030	32.87	✓		T	
38.81	+/-0.030	38.81	✓		T	
45.00	+/-0.030	45.00	✓		T	
48.25	+/-0.030	48.25	✓		T	
58.38	+/-0.030	58.38	✓		T	
61.25	+/-0.030	61.25	✓		T	
64.13	+/-0.030	64.13	✓		T	
64.63	+/-0.030	64.63	✓		T	
66.50	+/-0.030	66.50	✓		T	
7.50	+/-0.030	7.50	✓		T	
9.50	+/-0.030	9.50	✓		T	
10.38	+/-0.030	10.38	✓		T	
10.88	+/-0.030	10.88	✓		T	
14.50	+/-0.030	14.50	✓		T	
16.56	+/-0.030	16.56	✓		T	
18.75	+/-0.030	18.75	✓		T	
24.13	+/-0.030	24.13	✓		T	

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68584
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50	x		T HB 1	
30.50	+/-0.030	30.50	x		T	
33.88	+/-0.030	33.88	x		T	
39.50	+/-0.030	39.50	x		T	
40.25	+/-0.030	40.25	x		T	
43.50	+/-0.030	43.50	x		T	
46.60	+/-0.030	46.60	x		T	
7.63	+/-0.030	7.63	x		T	
11.00	+/-0.030	11.00	x		T	
11.50	+/-0.030	11.50	x		T	
16.75	+/-0.030	16.75	x		T	
19.00	+/-0.030	19.00	x		T	
22.50	+/-0.030	22.50	x		T	
30.75	+/-0.030	30.75	x		T	
32.63	+/-0.030	32.63	x		T	
32.75	+/-0.030	32.75	x		T	
35.13	+/-0.030	35.13	x		T	
36.50	+/-0.030	36.50	x		T	
40.00	+/-0.030	40.00	x		T	
41.88	+/-0.030	41.88	x		T	
43.63	+/-0.030	43.63	x		T	
0.125	+/-0.010	0.125	x		✓ HB 02	

Measured by: P	Audited by: S	Prototype Approval:	N/A
Date: 11-4-12	Date: 11/04/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

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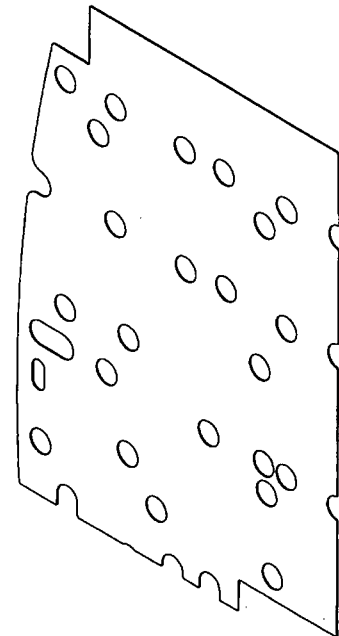
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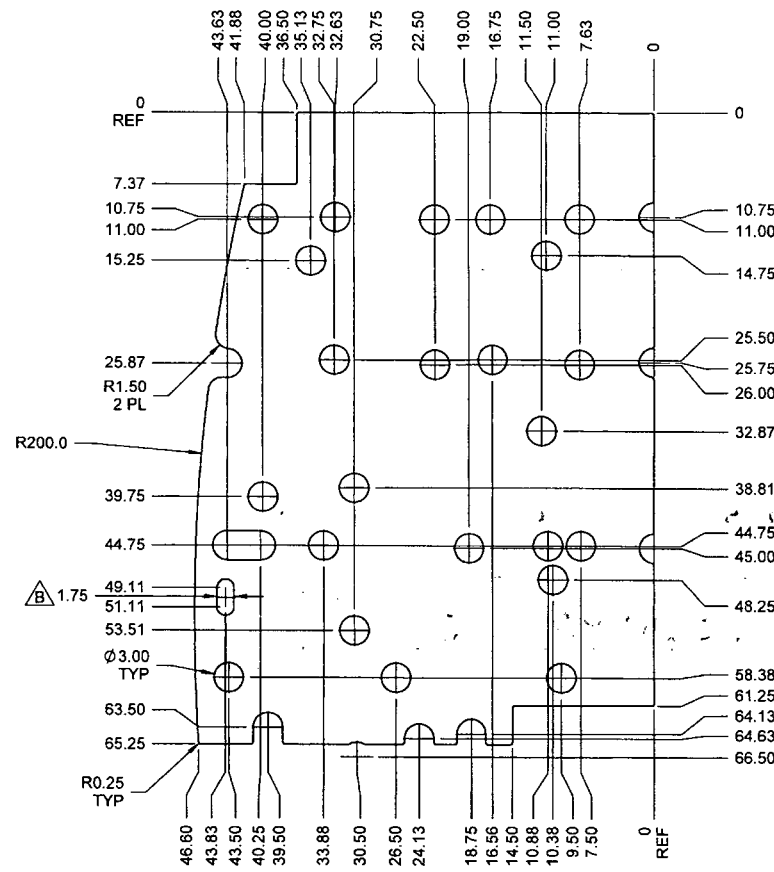
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68534

11-04-14



RELEASED
09/04/07



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3574	REV. B
TITLE CABIN FLOOR PROTECTOR	SCALE NTS
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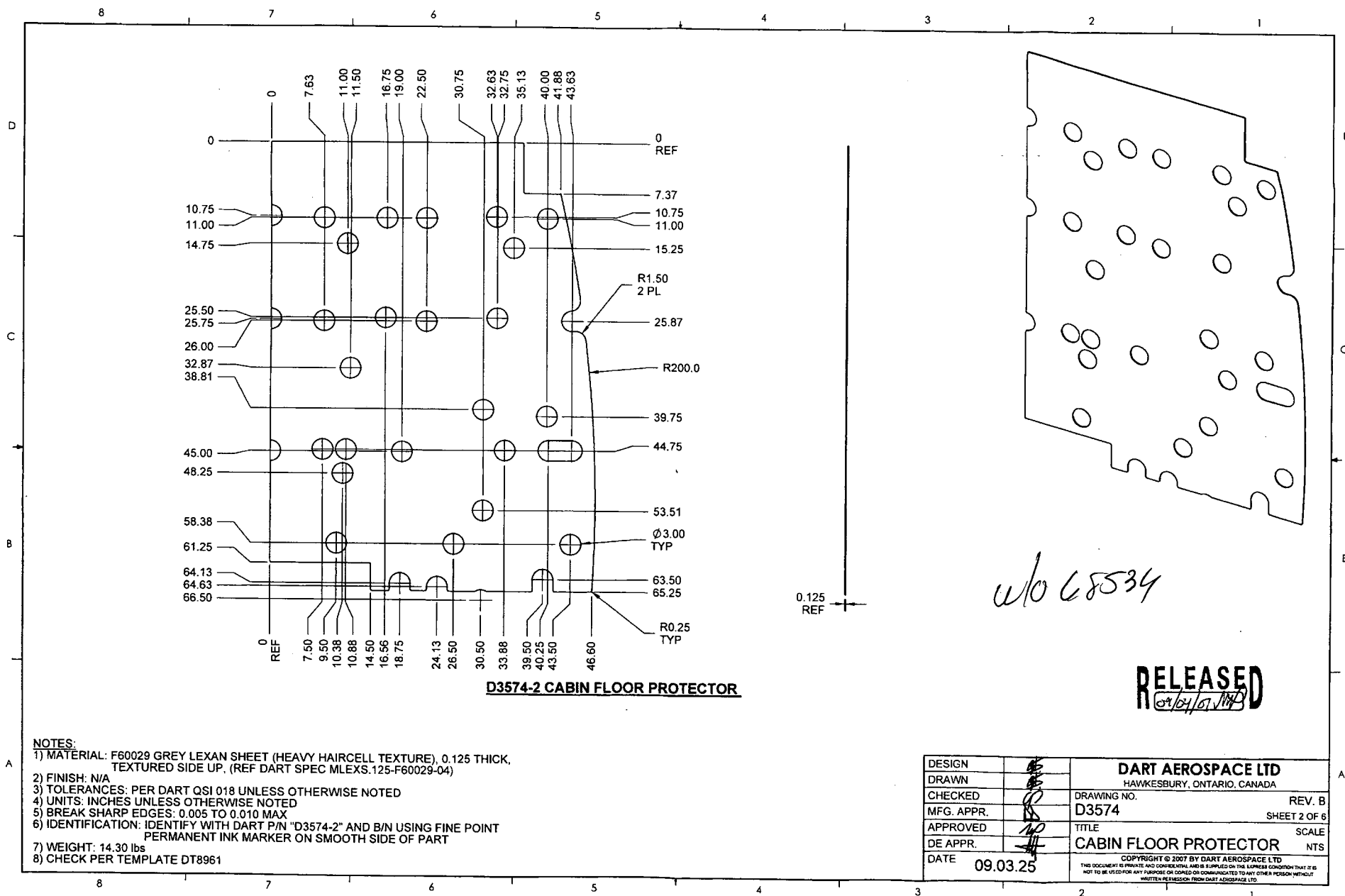
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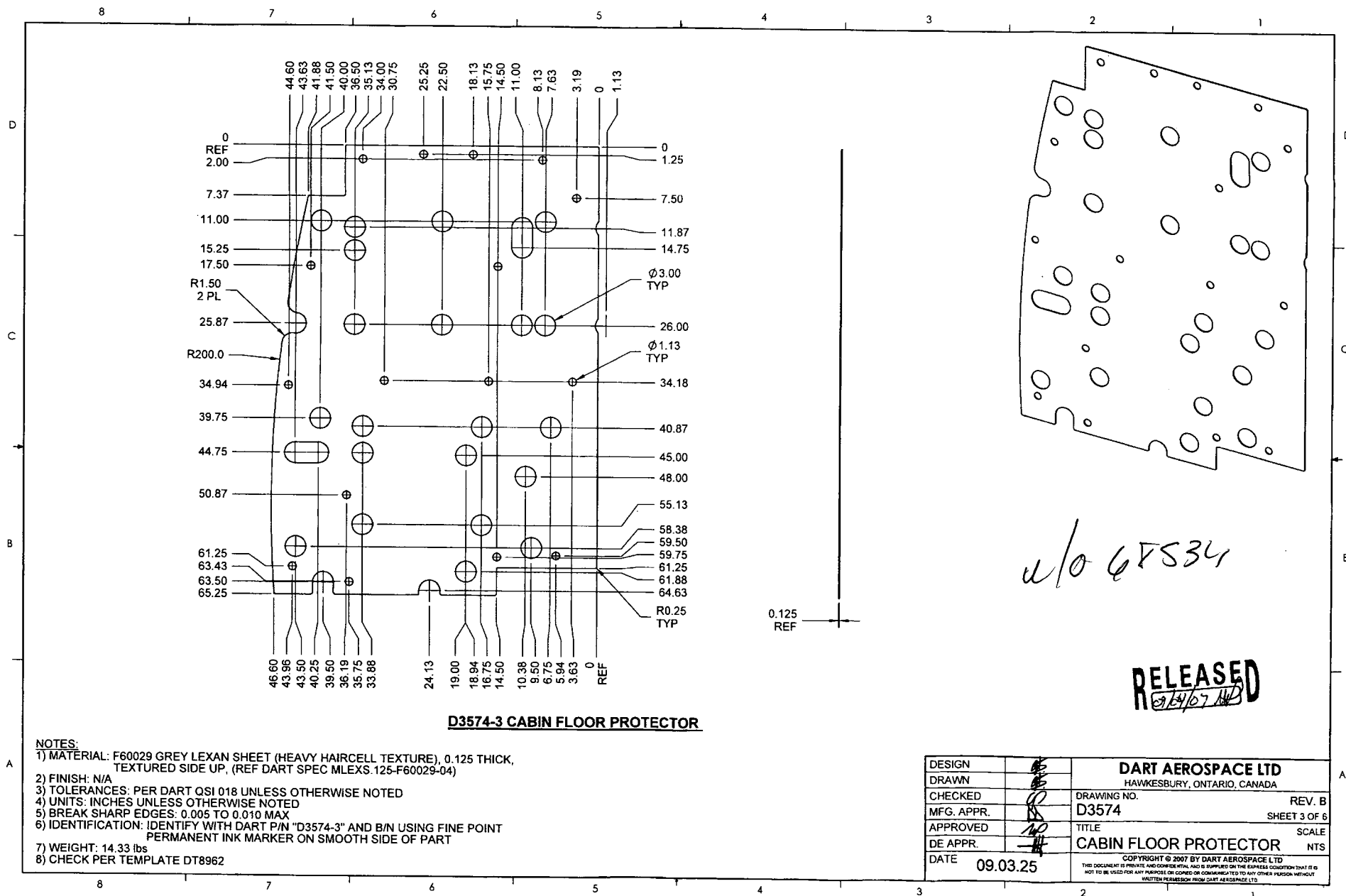
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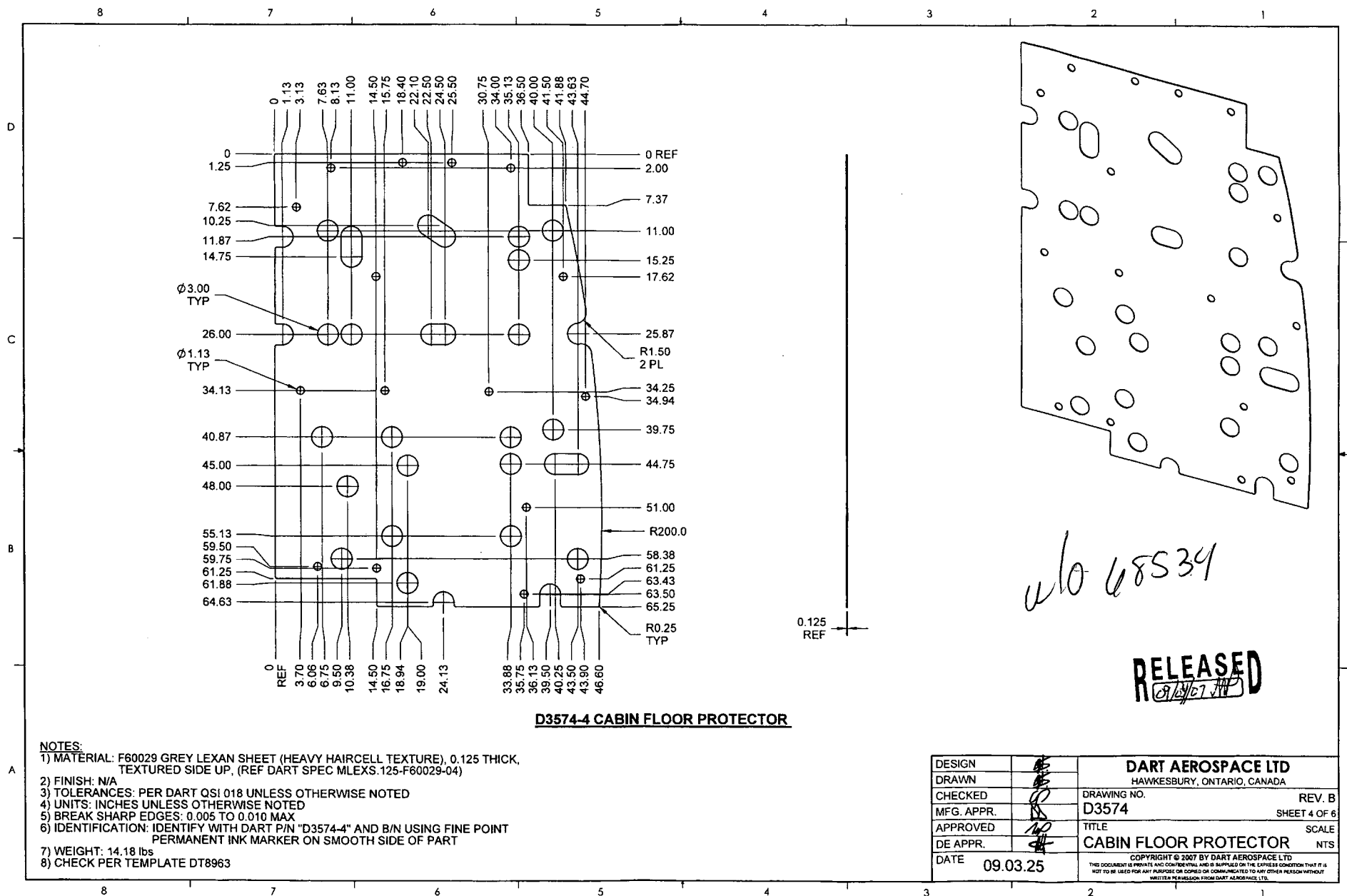
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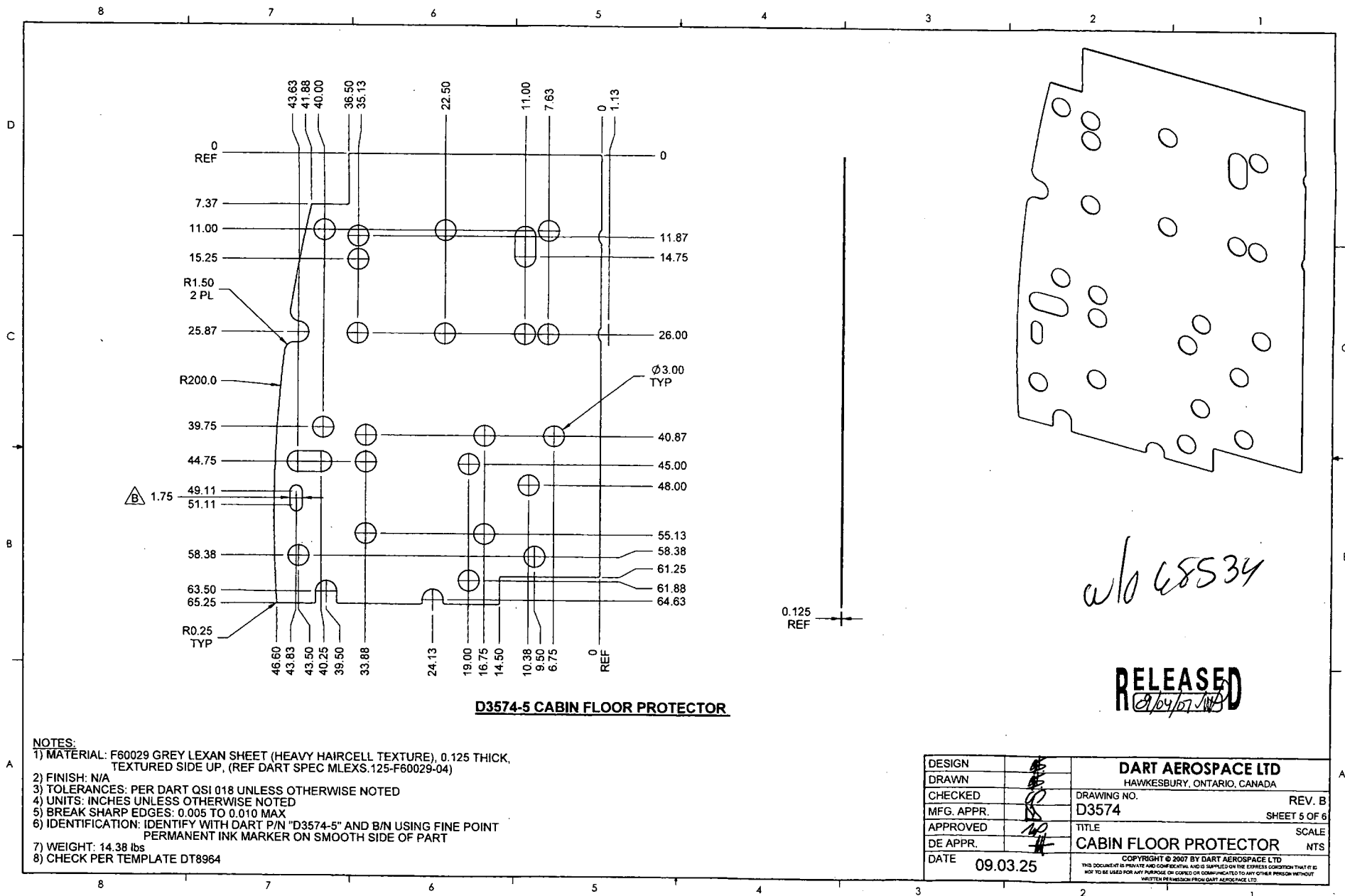
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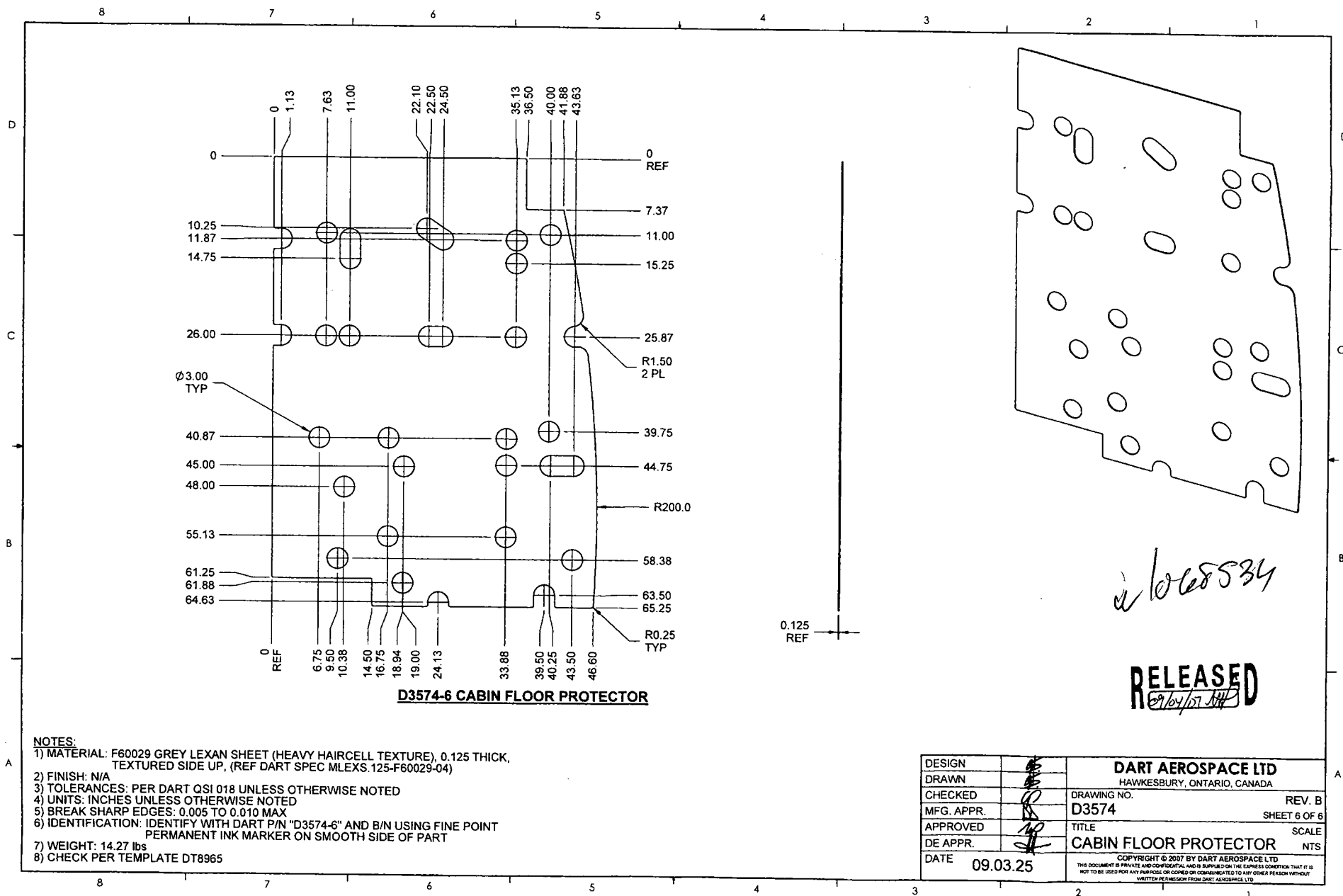
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